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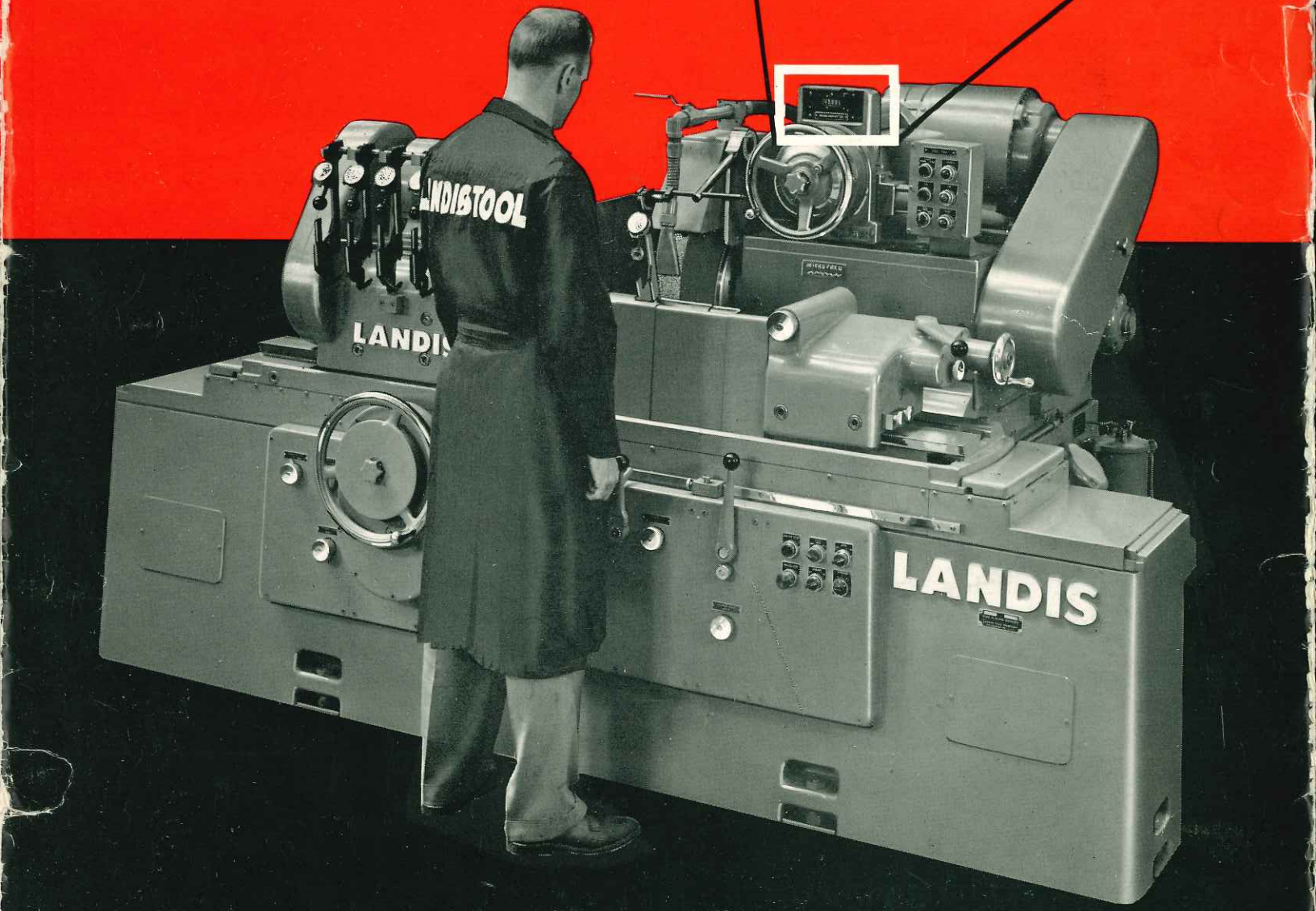
New

LANDIS SIZE FINDER

with MICROFEED

for fast, accurate grinding of multiple diameter work



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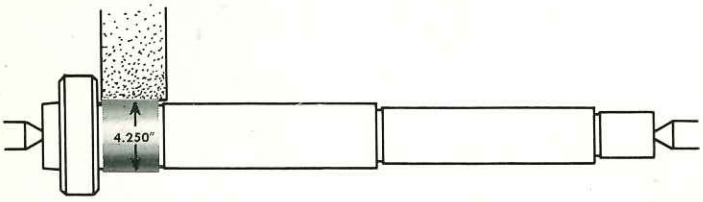
LANDIS TOOL COMPANY • WAYNESBORO, PENNSYLVANIA

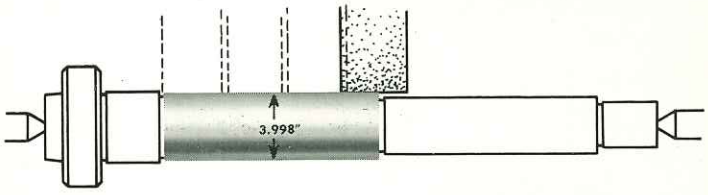
Here's a typical example of grinding a multiple diameter shaft with the new Landis SIZE FINDER and Microfeed

1 Set 4.250″ diameter on size finder



Traverse the carriage until the diameter to be ground is in line with the grinding wheel. The operator starts the grinding cycle, and applies the sizing gage. When the sizing gage shows size has been reached, the operator retracts the wheel head and traverses the carriage to the next diameter to be ground.

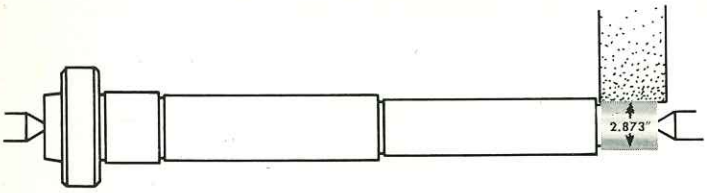
2 Set 3.998″ diameter on size finder



On this diameter, which is wider than the width of the wheel, a series of overlapping plunge cuts quickly removes stock until the shaft is a few "tenths" oversize. A final traverse pass using MICROFEED blends these plunge cuts, and grinds the shaft to finish size. Dimensional accuracy to "tenths" or better is achieved.

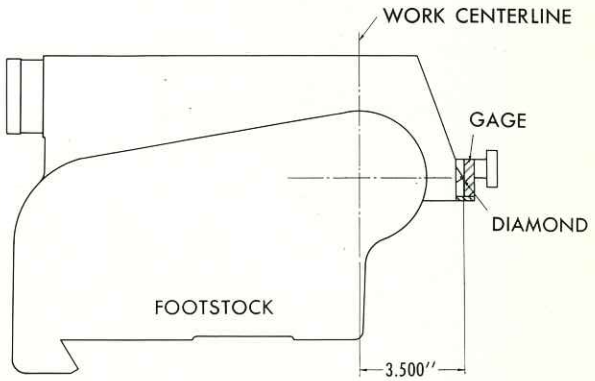
The SIZE FINDER is available on new Landis plain grinders for grinding small to medium lots of multiple diameter shafts in plants that manufacture special machinery, machine tools, pumps and compressors, electric motors, and numerous other types of machinery.

3 Set 2.873″ diameter on size finder



For this plunge cut, the operator repeats the grinding procedure used in Step 1. The high degree of roundness and finish is equal to or exceeds work that can be done by a highly skilled operator using time consuming "cut-and-try" methods. Uniform quality of work is assured. Grinding time on a shaft similar to the shaft shown here was cut 40% over the previous grinding method.

DRESSING THE WHEEL on machines with the new LANDIS SIZE FINDER



There's no guess work when dressing the wheel on a machine with the Landis Size Finder. A handy gage supplied with the machine assures accurate positioning of the diamond point in relation to the work center line. This gage calibrates the Size Finder to the grinding wheel.

To dress, set the Size Finder to the 7.000″ dimension as shown. MICROFEED enables the operator to dress at this same 7.000″ Size Finder reading for the life of the grinding wheel.

This SIZE FINDER with MICROFEED shows remarkable savings grinding multiple diameter shafts.

- **Positive direct reading indicator cuts set-up time.**
- **Simple operation even for unskilled operators.**
- **Practically eliminates costly rejects common to "cut-and-try" methods.**
- **Landis MICROFEED assures "tenths" tolerances consistently.**

MICROFEED

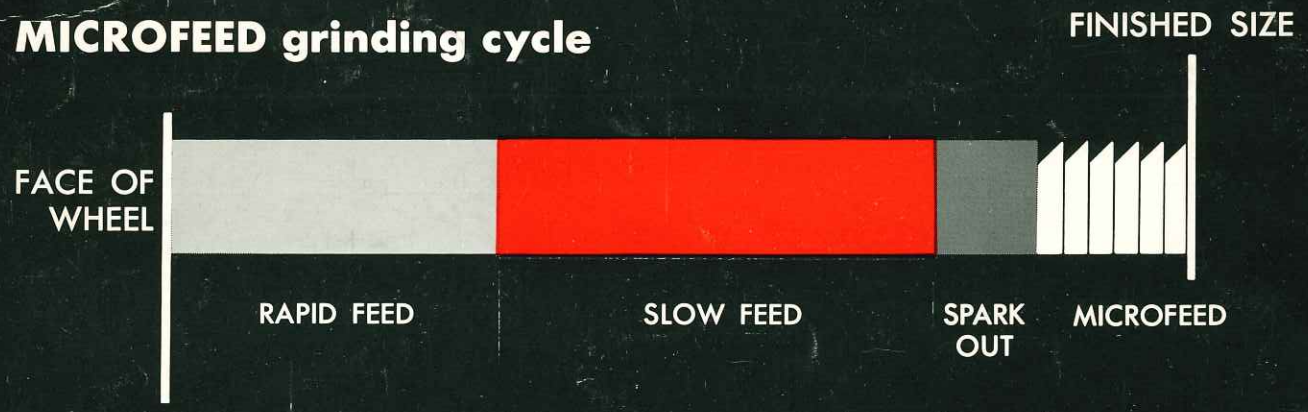
This new Landis feed system is an essential part of the SIZE FINDER.

Here's what MICROFEED does for cylindrical grinding:

- Automatically cancels the effects of thermal changes within the machine, wheel wear, variations in cutting action of the wheel, and all variations in the feed elements.
- Permits grinding to "tenths" or "millionths" on a production basis.
- Increases production by grinding MORE usable pieces of work.
- Accurately adjusts feed when required — automatically.
- Assures uniformity for size, roundness, and finish.

SF-60

MICROFEED grinding cycle



MICROFEED is applicable:

To any production or small lot job that justifies and uses automatic or visual gauging. MICROFEED uses an in-process single contact, or visual gauge to control work size.

Where tolerances in low "tenths" or "millionths" are required. The ultra-fine feed assures these close tolerances on a production basis. Assures MORE usable pieces of work.

Where uniformity of size, roundness and finish is necessary. The constant sparkout causes each piece to be ground to the same degree of size, roundness and finish.

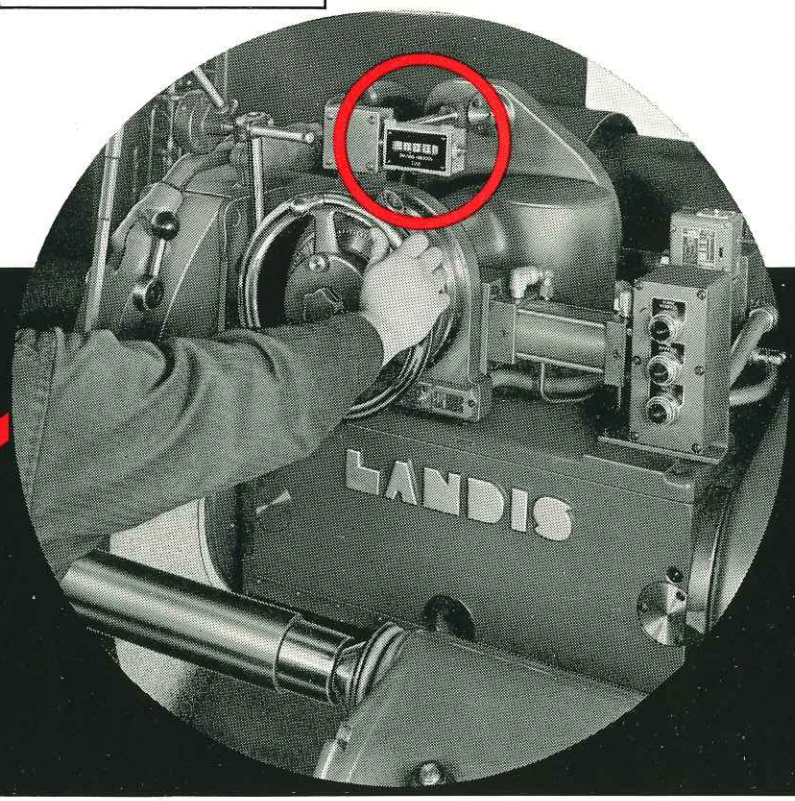
To any job where it is not desirable to have the operator adjust, or monitor, the feed handwheel to compensate for grinding variables.

Printed in United States of America

Rocks.

New idea cuts cost

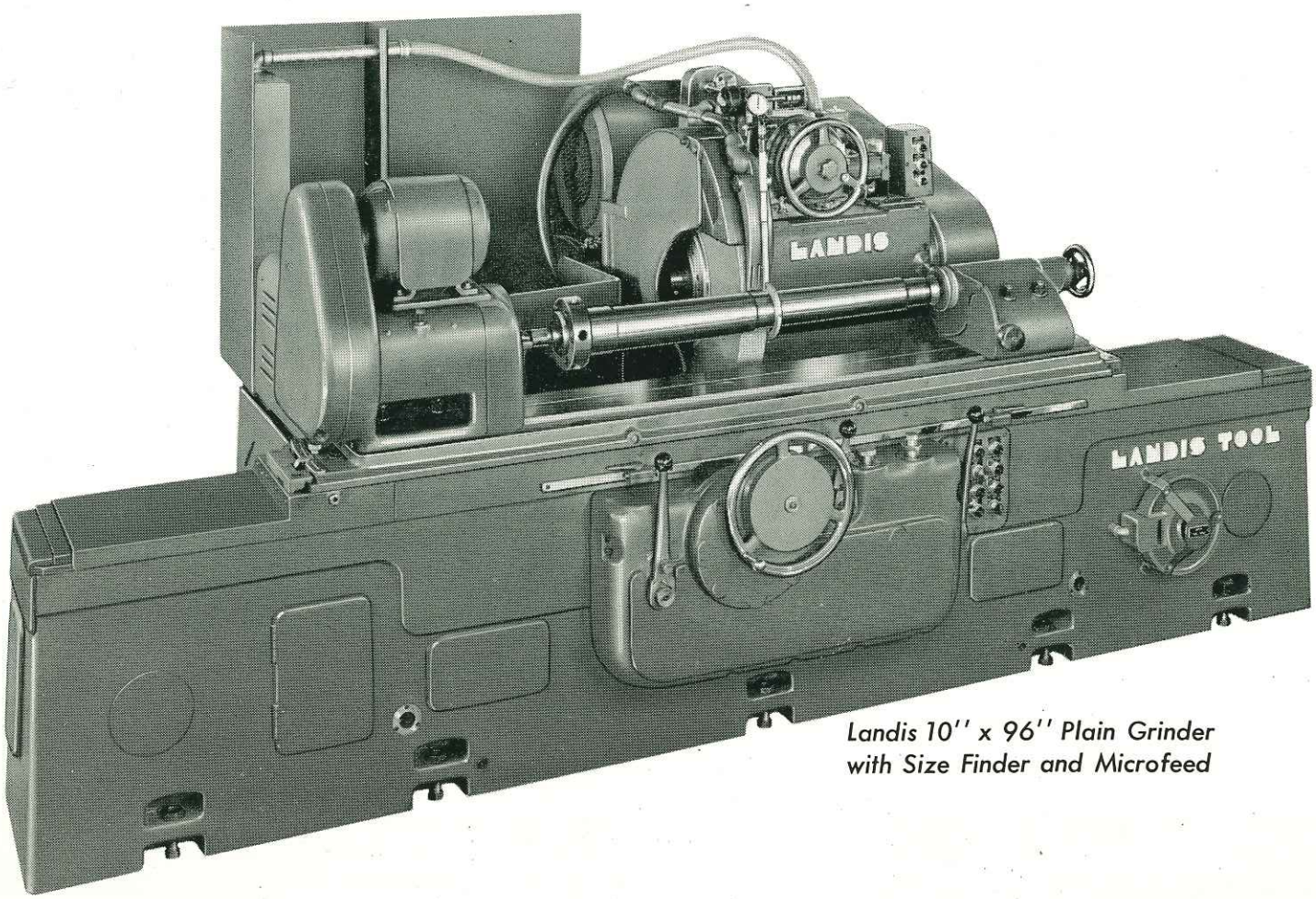
LANDIS size finder with MICROFEED



Positive direct reading size finder cuts setup time

Landis MICROFEED assures "tenths" tolerances consistently

Eliminates costly rejects



Landis 10'' x 96'' Plain Grinder with Size Finder and Microfeed

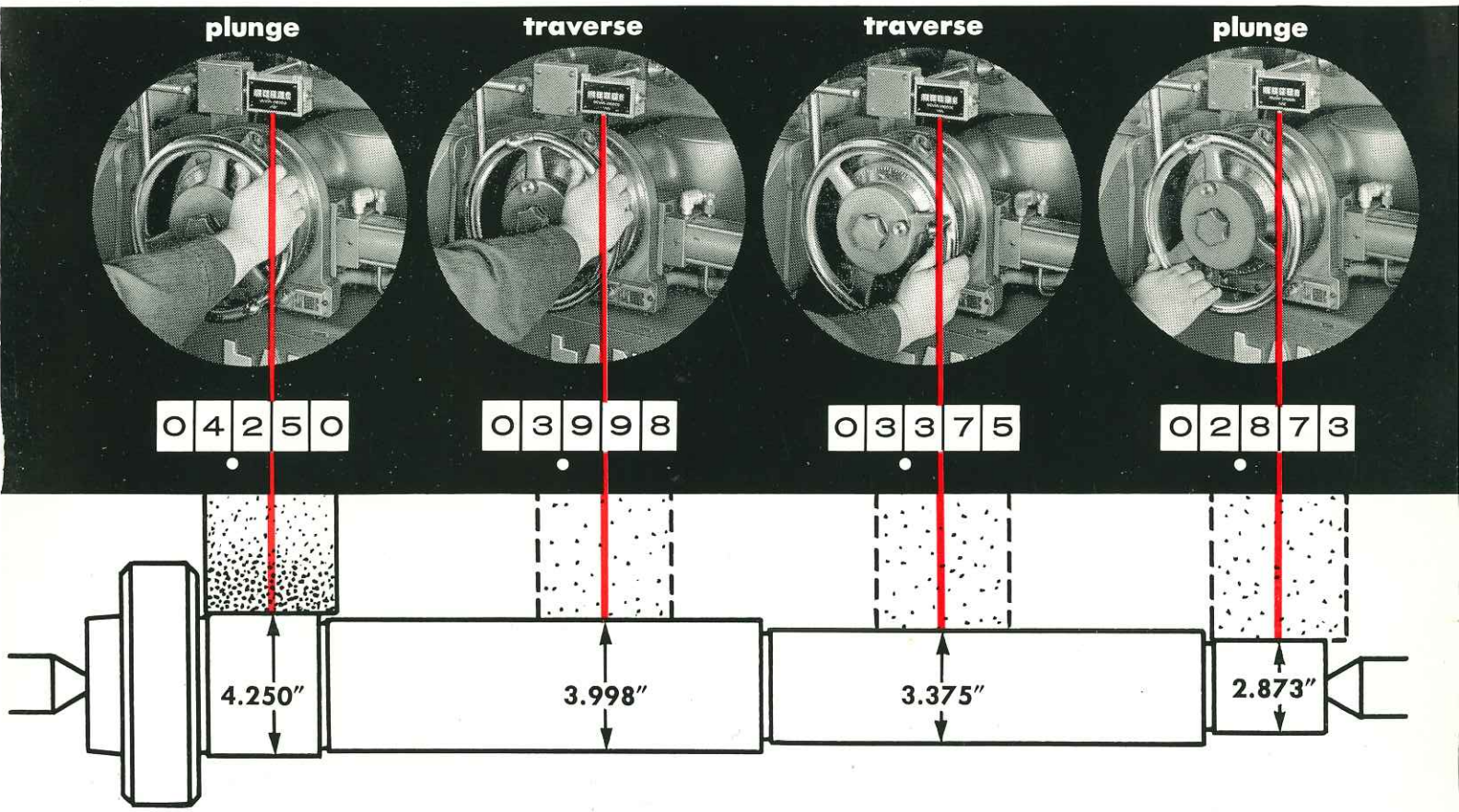
Ad #249

This advertisement appears in AMER

# of grinding shafts

shows remarkable savings on small lots

finish sizes set on direct reading dial



how size finder works

The operation of the machine is simple, even for unskilled operators. It's only necessary to set the finish dimension on the indicator by turning the wheel feed handwheel. Operator starts the cycle, applies the sizing gauge and stops the cycle when the gauge shows finish size. He moves the work table, resets the Size Finder for the next diameter and repeats the cycle.

You can make large savings on your small lot multiple diameter shaft grinding operations. Send us prints of your shafts for our proposal.

LANDIS

precision grinders

LANDIS TOOL COMPANY / WAYNESBORO, PENNSYLVANIA

Pages 12 and 13 from copy in Library